

Duplicate

Work Order ID 81565

81565

Page 1

April-13-12 7:01:02 AM

Item ID: D3267-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket lid Assembly (Outside)

Start Date: 3/15/12 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/13/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3267

Rev C

100

Weld per dwg A/R S.S. rod Batch: *118366* 0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr & Remove All Markings From Material

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267 Identify as D3267-041

automatic lid

IX *12.04.14* *12.04.16*

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Page 2

April-13-12 7:01:02 AM

Item ID: D3267-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket lid Assembly (Outside)

Start Date: 3/15/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 4/13/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00


110

QC

Memo

0.00

Quality Control

 12.04.16

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

8/7/16

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Item ID: D3267-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket lid Assembly (Outside)

Start Date: 3/15/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/12 Req'd Qty: 1.00

1

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

130

Powdercoat

Powder Coating

Memo

0.00

POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

0.00

140

HandFinish

Hand Finishing

HandFinishing

Memo

0.00

Wing walk as per Dwg D3267 and QSI 005 4.4

Spray Paint Black:

Wing Walk:

IX

M-h
12/24/16

1

12-4-16.

121134

1:00
START TIME: 1:40 OF
OVEN TEMPERATURE: 1:50 OF
FINISH TIME: 2:10

118114
120902

Work Order ID 81565

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April-13-12 7:01:02 AM

Item ID: D3267-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Basket lid Assembly (Outside)

Stop

NS2

Start Date: 3/15/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/13/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 x ϕ

SL 12/04/16

155

Identify as per dwg & Stock Location: **D350-607-047 A**

81564

155

Packaging

Memo

0.00

Packaging

1

BL 12-4-17.

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/4/17

12-04-17

Picklist Print

April-13-12 7:01:01 AM

Page 1

Work Order ID: 81565

Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 3/15/12

Required Date: 4/13/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed -043 05-11-04 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC
I.D. DD 10.03.11 verified by:EC

IPP Rev:E add

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 Spacer Bushing		Manufactured	No			100	Each	13.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		13							
				75564		1							
				77229		1							
				81144		11							
D2506 Label Plate		Manufactured	No			100	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		7							
				79197		7							
D2581 Mounting Bracket		Manufactured	No			100	Each	32.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		26							
				82506		26							
				WA005		6							
				69739		1							
				70766		2							
				77045		1							
				81253		2							
D3166-3 Basket Hoop		Manufactured	No			100	Each	7.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				81578		6							
				WA007		1							
				77294		1							

Picklist Print

April-13-12 7:01:01 AM

Page 2

Work Order ID: 81565

Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 3/15/12

Required Date: 4/13/12

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100 sf

947.2254

7.8

8.2105263

Expanded Metal Flat SS

SAD 12-04-13

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	320	
121347	320	
WA	0.0001156	
119180	0.0001156	
WA035	627.2252641	
117197	102.9036	
117896	29.49258	
118153	76.8473	
118955	82.17	
119180	53.6958107	
119729	28.1132686	
120153	2.97557478	
120917	170.88713	
121082	80.14	

8.2105

M304TS0.750W.065

Purchased

No

100 f

1,072.6352

30.6

32.210526

304 SQ Tube .75x.75x.065W

SAD 12-04-13

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT017	553.7325342	
120267	53.7325342	
120633	500	
MAT018	512.24519	
121170	471.24519	
7636	41	
WA007	0.5907428	
116763	0.5907428	
WA035	6.0667	
118181	6.0667	

32.2105

April-13-12 7:01:01 AM

Shop Packet Print

Page 2

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

81565

RELEASED
08-09-14

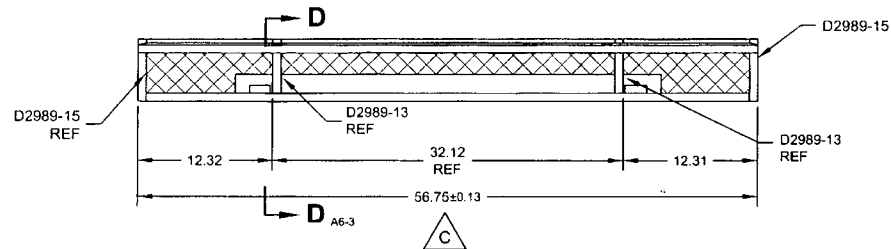
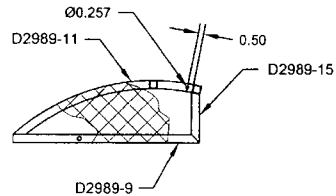
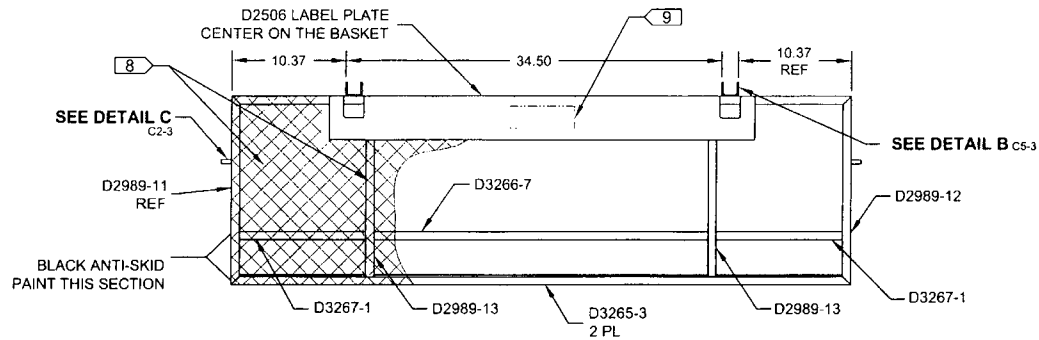


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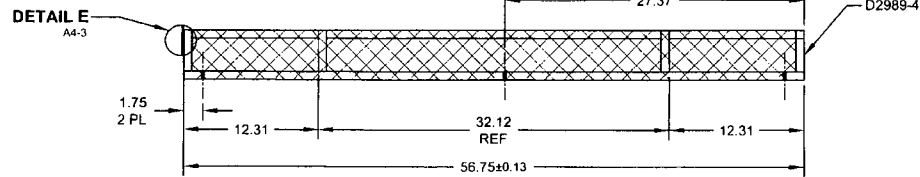
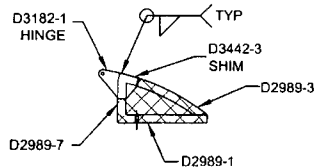
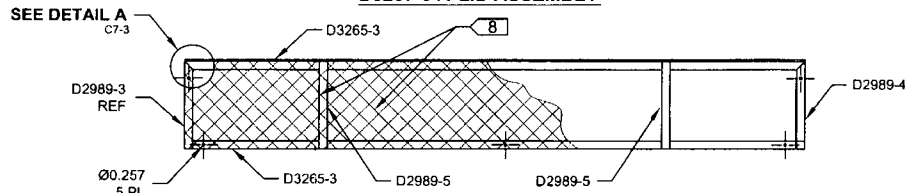
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DRAWING NO. REV. C D3267 SHEET 1 OF 3 TITLE SCALE BASKET LID ASSEMBLY NTS	
DATE	08.08.15	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1



D3267-041 LID ASSEMBLY



D3267-041 LID ASSEMBLY



NOTES:

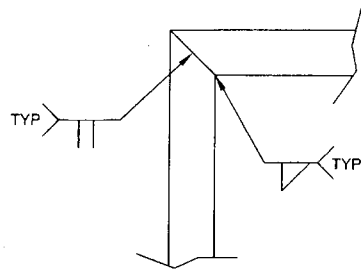
- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

RELEASED
08.07.04/10

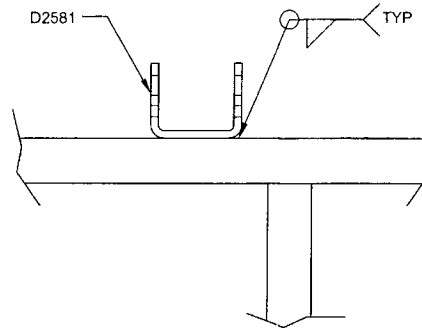
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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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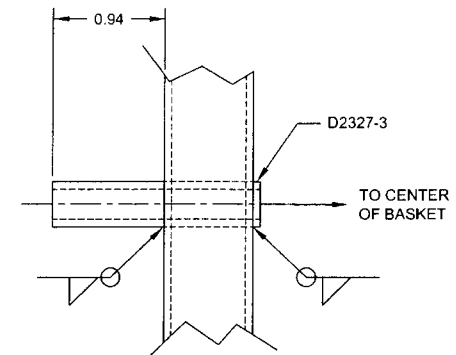
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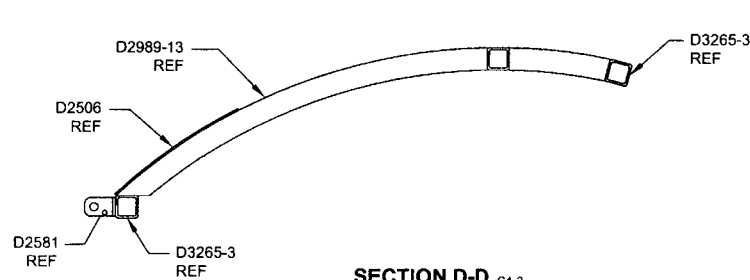
DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X



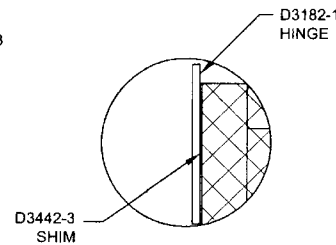
DETAIL B D2-2
2 PL
SCALE 2X



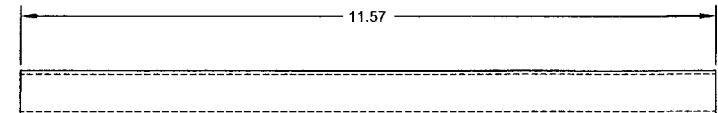
DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

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08-07-01/10

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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3267	3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSMEBLY	NTS
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8 7 6 5 4 3 2 1